

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73207

Friday, August 26, 2011 7:12:07 AM



Page 2

Item ID: D412-785-002-205

Accept



Setup Start



Revision ID:

Stop



Item Name: Angle Assembly

Start Date: 8/26/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00

B.A. 11/09/14

2

0



QC

Memo

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

Hand Finishing

2x 0 m-p 11/09/14

150

QC3- Inspect Part Finish

0.00



QC

Memo

Quality Control

counted

2

0

11/09/14

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73207

Page 3

Friday, August 26, 2011 7:12:07 AM

Item ID: D412-785-002-205

Accept



Setup Start



Revision ID:

Stop



Item Name: Angle Assembly

Start Date: 8/26/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

0.00



Small Fab

Memo

0.00

Small Fab

ASSEMBLE NUT PATES AS PER DWG

8/24/09/14 (2)

170

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

8/24/14

(42)

205

180

0.00



Packaging

Identify as per dwg & Stock Location: _____

Memo

0.00

Packaging

8/24/14 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73207

Page 4

Friday, August 26, 2011 7:12:08 AM

Item ID: D412-785-002-205

Accept



Setup Start



Revision ID:

Stop



Item Name: Angle Assembly

Start Date: 8/26/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/14

M2024T3 1.25X.063

M118881

1.25 11/09/14

ME
11-09-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, August 26, 2011 7:12:05 AM

Page 1

Work Order ID: 73207

Parent Item: D412-785-002-205

Parent Item Name: Angle Assembly



Start Date: 8/26/2011

Required Date: 9/9/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 11-08-25 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6A1.00X.500W
.063

Purchased

No

f

0.0000

0.526316



angle 1.00 x .500 x .063w

MS20426AD3-#3

11.09.14
051042

Purchased

No

Each

5,040.000

8



RIVET

M19099 (8x)

Location

Loc Qty

Loc Code

ST316

5040

104374

1122

110398

3918

MS21075L08

Purchased

No

Each

86.0000

4



ANCHOR NUT

Location

Loc Qty

Loc Code

ST303

86

111578

86

~~M2024T3 1.25 x 0.063~~

~~M118881~~

~~1.25 11/09/14~~

8
11/09/14

4
11/09/14

4
11/09/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

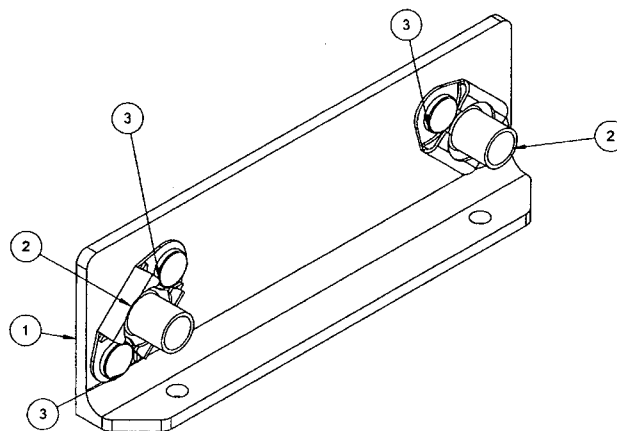
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM NO.	QTY. -205	PART NUMBER	DESCRIPTION
1	1	D412-785-002-405	ANGLE
2	2	MS21075L08	NUTPLATE
3	4	MS20426AD3-4	RIVET



D412-785-002-205 ANGLE ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 73207
CZ11108/26

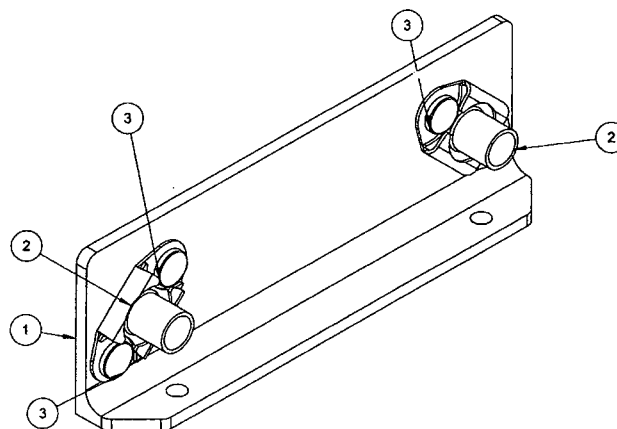
RELEASED
10/6/25 W

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

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MFG. APPR.	N/A	D412-785-002-101	SHEET 4 OF 8
APPROVED	<i>AE</i>	TITLE	SCALE
DE APPR.	N/A	GPS PANEL INSTALLATION	NTS
DATE	09.10.09	<small>COPYRIGHT © 2008 BY EAGLE COPTERS MAINTENANCE THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM EAGLE COPTERS MAINTENANCE LTD.</small>	

ITEM NO.	QTY. -205	PART NUMBER	DESCRIPTION
1	1	D412-785-002-405	ANGLE
2	2	MS21075L08	NUTPLATE
3	4	MS20426AD3-4	RIVET



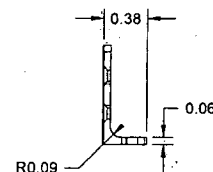
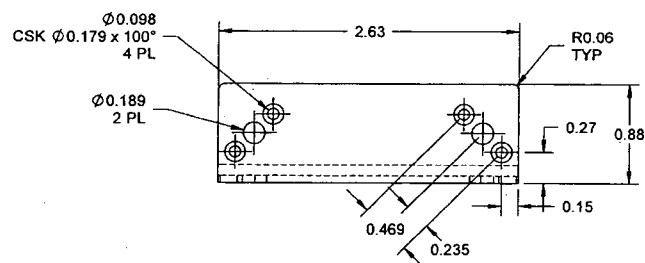
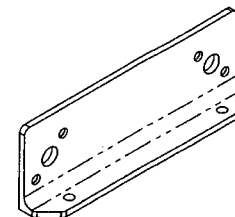
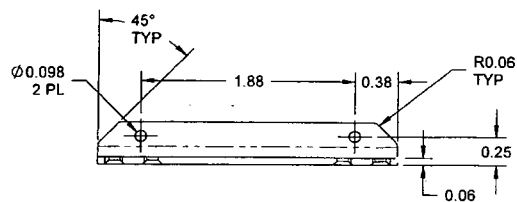
D412-785-002-205 ANGLE ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

RELEASED
10/6/25 WPD

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D412-785-002-405 ANGLE

RELEASED
10/8/25 NW

NOTES:

- 1) MATERIAL: 6061-T6/6510/T6511 ALUMINUM ANGLE PER AMS-QQ-A-200/8
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

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APPROVED	<i>[Signature]</i>	TITLE	SCALE
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From: Harvey Siemens <hsiemens@dartaero.com>
Sent: September 12, 2011 5:26 PM
To: L Lacelle; Jean-Luc Menard
Subject: Angle

Linda/JL

There are 2' of 2024, 1.25 x 1.25 (sorry the size changed when they actually measured it) angle headed your way for the production of D412-785-002-403/-405.

It is acceptable to substitute the 2024 material for the 6061 material called out in the drawing.

You should see them tomorrow. They are coming to your attention JL.

Let me know if there's anything else that you need.

Regards,

Harvey Siemens

Mechanical Designer
DART Aerospace Ltd.

P: 403-717-0328

F: 403-717-1288

E: hsiemens@dartaero.com

W: www.dartaero.com

M: 1060 McTavish Road NE, Calgary, Alberta, T2E 7G6

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